

# Work Order ID 58234

Friday, April 30, 2010 12:58:11 PM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *mf*

Date: *10-4-30*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3913

A

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *4113228* 0.00  
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913  
\*\*\*inspect before welding mesh\*\*\*  
2- tack weld mesh on basket as per dwg D3913  
3- weld hinge (3) and Mounting brackets as per dwg D3913  
\*\*\*take lid to locate hinge and bracket\*\*\*

*10/05/04* (14)

*10.05.04* (1)

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

*10.05.04*

# Work Order ID 58234

Friday, April 30, 2010 12:58:11 PM



Page 2

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/4/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Scolorloc



Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

=> M 10/05/06

1 0

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 2:30pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:00pm

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: 3:15pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:45pm

**Work Order ID 58234**

Friday, April 30, 2010 12:58:11 PM

Page 3

Item ID: D3913-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 5/4/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

① BR 10-5-6

150

Assemble as per dwg

0.00

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

EP 10/05/07

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8 w/05/07



④


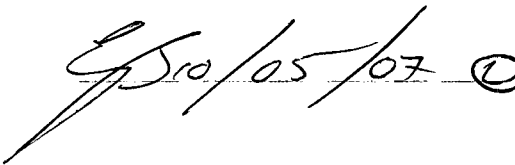

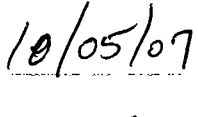
**Work Order ID 58234**

Friday, April 30, 2010 12:58:11 PM

Page 4

Item ID: D3913-041 Accept  Setup Start   
Revision ID: Stop   
Item Name: Long Basket Base Assembly, 350  
Start Date: 4/30/2010 Start Qty: 1.00  Cust Item ID:  
Required Date: 5/4/2010 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>G-A</u> <u>W/O 58317</u> Memo	0.00  0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							 MF 10-5-7

# Picklist Print

Friday, April 30, 2010 12:58:09 PM

Page 1

Work Order ID: 58234

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 4/30/2010

Required Date: 5/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-10A Bolt		Purchased	No			150	Each	112.0000	6		4/30/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST351		112						
					11119	12						
					114330	100						
AN960JD8 Washer	051015 NAS1149DN8321	Purchased	No			150	Each	0.0000	2		4/30/07	
D2581 Mounting Bracket		Manufactured	No			100	Each	27.0000	2		PD 10.04.30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		27						
					46086	2						
					51745	2						
					57185	23						
D2931 Bumper		Manufactured	No			150	Each	872.0000	2		4/30/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		872						
					46064	872						
D3913-1 Rib		Manufactured	No			100	Each	0.0000	1		PD 10.04.30	

B58124 -> ①

# Picklist Print

Friday, April 30, 2010 12:58:10 PM

Work Order ID: 58234



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/4/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
✓ D3913-15  Wide Handle Plate		Manufactured	No			100	Each	2.0000	1		PD 10.04.30	

Location Loc Qty Loc Code

WA 2  
57079 2

✓ D3913-3  Rib		Manufactured	No			100	Each	7.0000	1		PD 10.04.30	
----------------------	--	--------------	----	--	--	-----	------	--------	---	--	-------------	--

Location Loc Qty Loc Code

WA 7  
57609 1  
58126 6

✓/✗ D3913-7  Rib		Manufactured	No			100	Each	0.0000	2		BS8127 PD 10.05.03	
------------------------	--	--------------	----	--	--	-----	------	--------	---	--	--------------------	--

✓/✗ D3913-9  Hinge Rib		Manufactured	No			100	Each	1.0000	1		BS8128 PD 10.05.03	
------------------------------	--	--------------	----	--	--	-----	------	--------	---	--	--------------------	--

Location Loc Qty Loc Code

WA 1  
57610 1

✓/✗ D3916-041  Rib Assembly		Manufactured	No			100	Each	0.0000	2		PD 10.04.30 BS8129 -> ②	
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# Picklist Print

Page 3

Friday, April 30, 2010 12:58:10 PM

Work Order ID: 58234



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/4/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3916-5		Manufactured	No			100	Each	2.0000	3			



Light Rib



PD 10.04.30

Location

Loc Qty

Loc Code

WA

2

57023

2

B58131 → ③

D4016-1

Manufactured No

100

Each

4.0000

3



Hinge Half, Base



PD 10.04.30

Location

Loc Qty

Loc Code

ST109

4

57611

4

③

✗ D4017-7

Manufactured No

100

Each

0.0000

1



Rib



B58133 PD 10.05.03

D4017-9

Manufactured No

100

Each

0.0000

2



Rib



B58134 → ② PD 10.04.30

→ D4020-1

Manufactured No

100

Each

0.0000

1



Mesh (350 Basket Long, Base)



B58135 PD 10.05.04

→ D4020-11

Manufactured No

100

Each

1.0000

2



End Mesh, Basket



58136 PD 10.05.04

Location

Loc Qty

Loc Code

WA

1

56990

1

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Shop Packet Print

Page 3

# Picklist Print

Page 4

Friday, April 30, 2010 12:58:10 PM

Work Order ID: 58234



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/4/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D4021-1  
  
Handle Plate

Manufactured No

100

Each

7.0000

3



PD 10.04.30

## Location

## Loc Qty

## Loc Code

ST109

7

B58139 → ①

57086

7

②

D4021-5  
  
Blanking Plate

Manufactured No

150

Each

4.0000

2



4/30/05/07

## Location

## Loc Qty

## Loc Code

ST109

4

2

57612

4

D4034-041  
  
Aft Upper Rib Assembly

Manufactured No

100

Each

4.0000

1



B57938 → ① PD 10.04.30

## Location

## Loc Qty

## Loc Code

WA

4

①

57988

4

D4034-043  
  
Fwd Upper Rib Assembly

Manufactured No

100

Each

4.0000

1



PD 10.04.30

## Location

## Loc Qty

## Loc Code

WA

4

①

58040

4

Friday, April 30, 2010 12:58:10 PM

Shop Packet Print

Page 4



# Picklist Print

Friday, April 30, 2010 12:58:10 PM

Work Order ID: 58234

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/4/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

MS20600-AD4W3

Purchased

No

150

Each

1,891.000

2



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1891

106375

3

107939

888

111636

1000

MS21042L3

Purchased

No

150

Each

1,816.000

6



Nut

Location

Loc Qty

Loc Code

ST300

1816

113537

20

113644

796

114523

1000

NAS1149F0332P

Purchased

No

150

Each

959.0000

12



WASHER

Location

Loc Qty

Loc Code

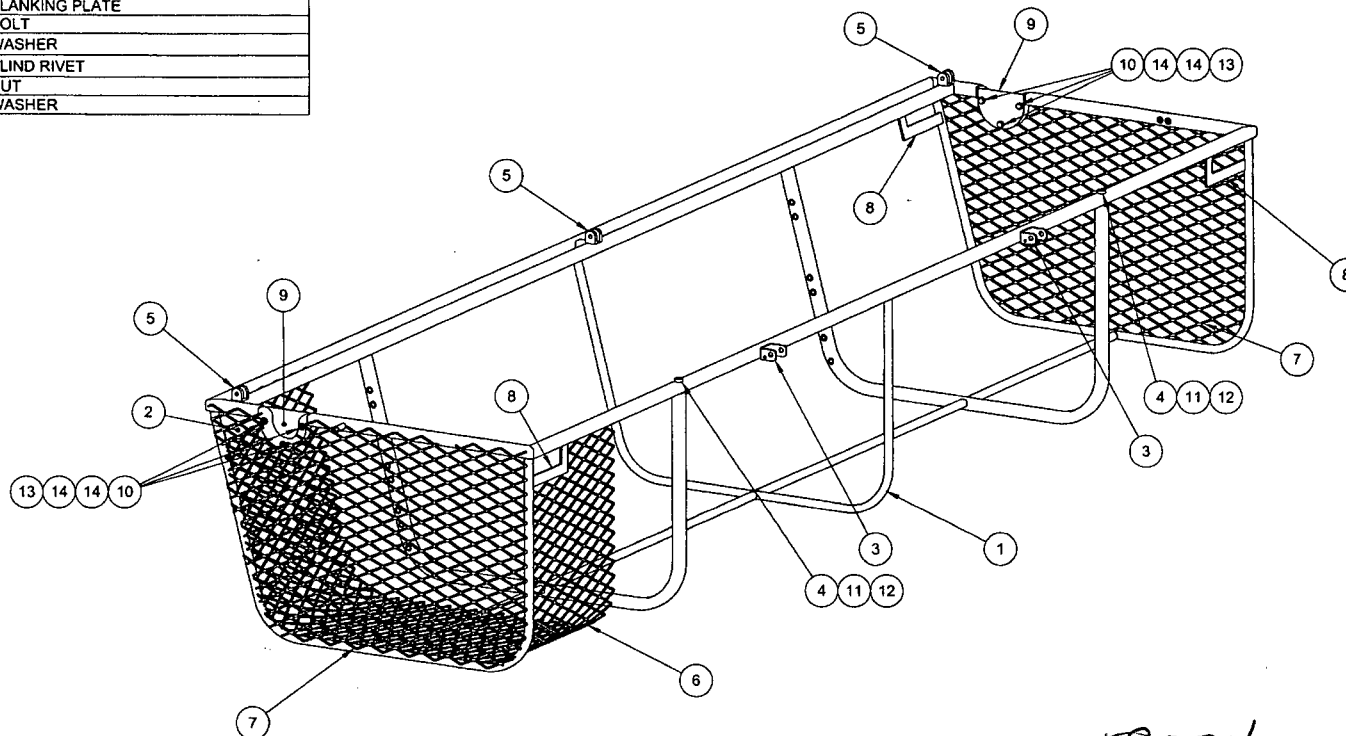
ST275

959

18057

959

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

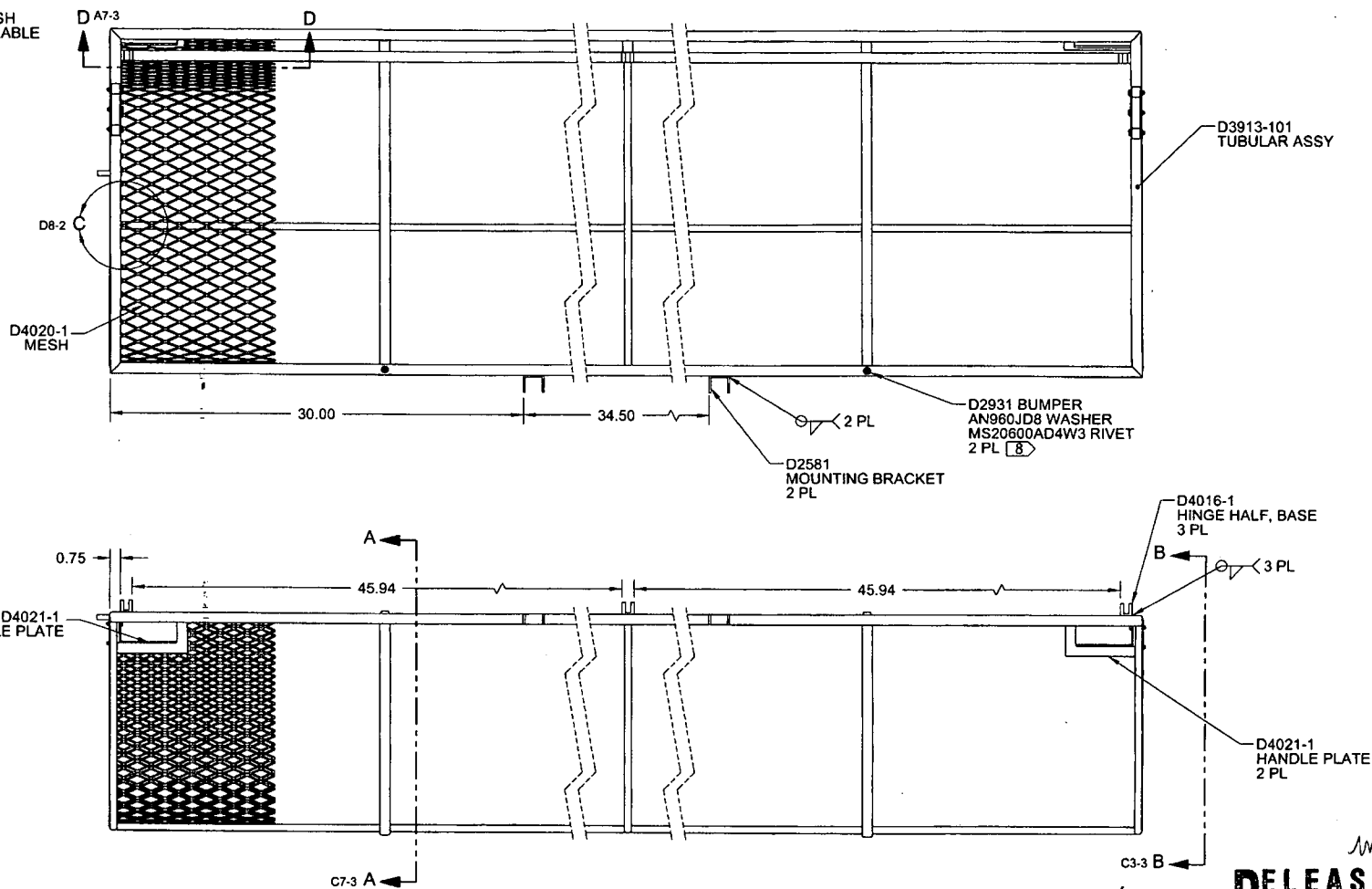
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2010-03-22  
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3913</b> TITLE <b>LONG BASKET BASE ASSY (350) NTS</b> SCALE SHEET 1 OF 6 REV. A COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	JPH		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	10.03.16		

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

**DETAIL C** D7-2

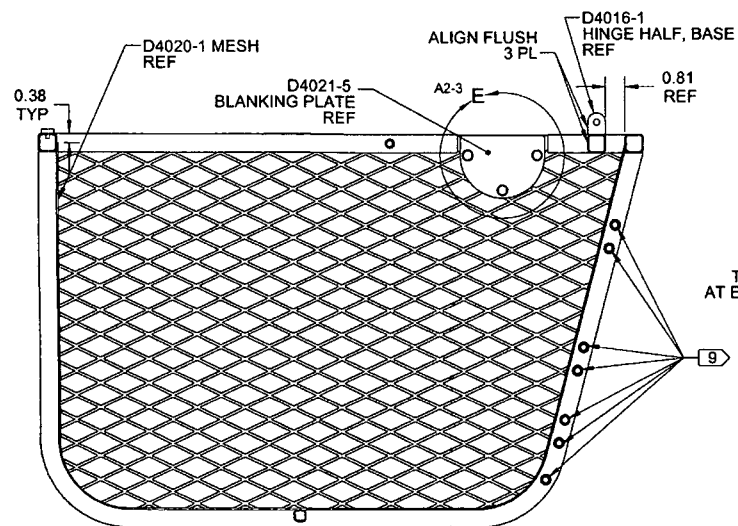


**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

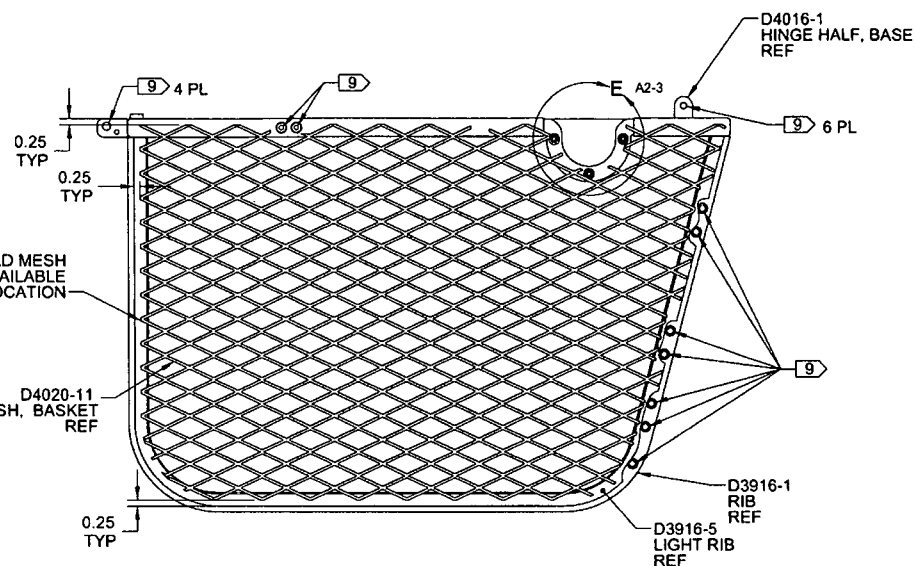
58234

**RELEASED**  
2010-03-16

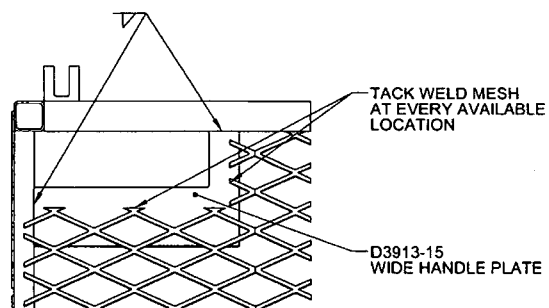
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



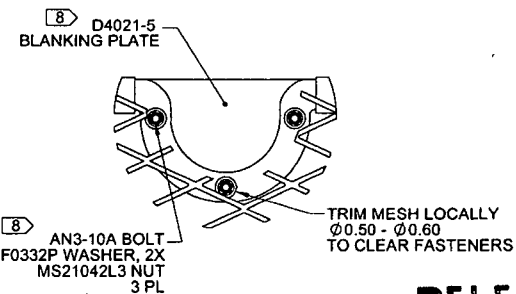
**SECTION A-A** A5-2



**VIEW B-B** A2-2



**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES

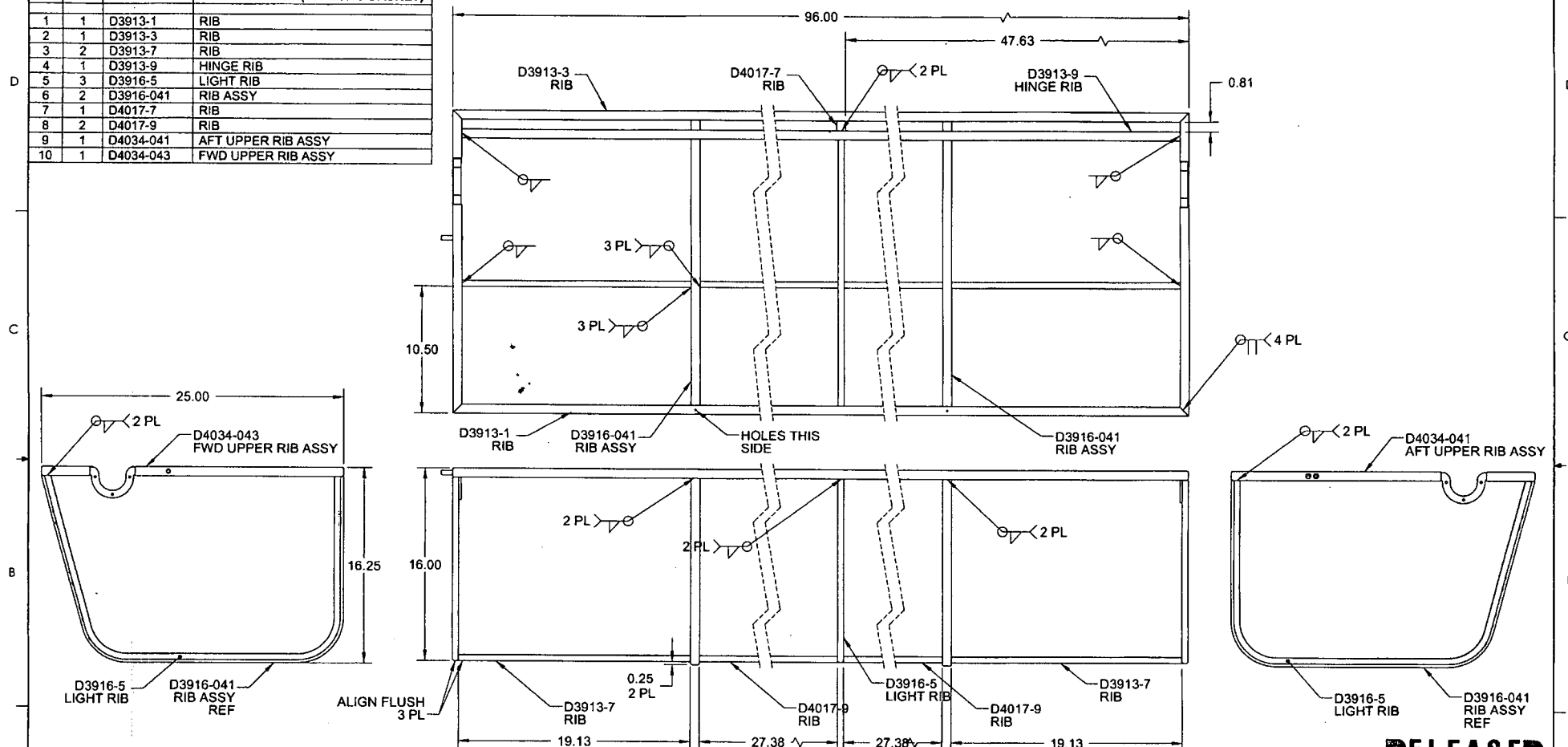


**DETAIL E** D2-3  
D6-3

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

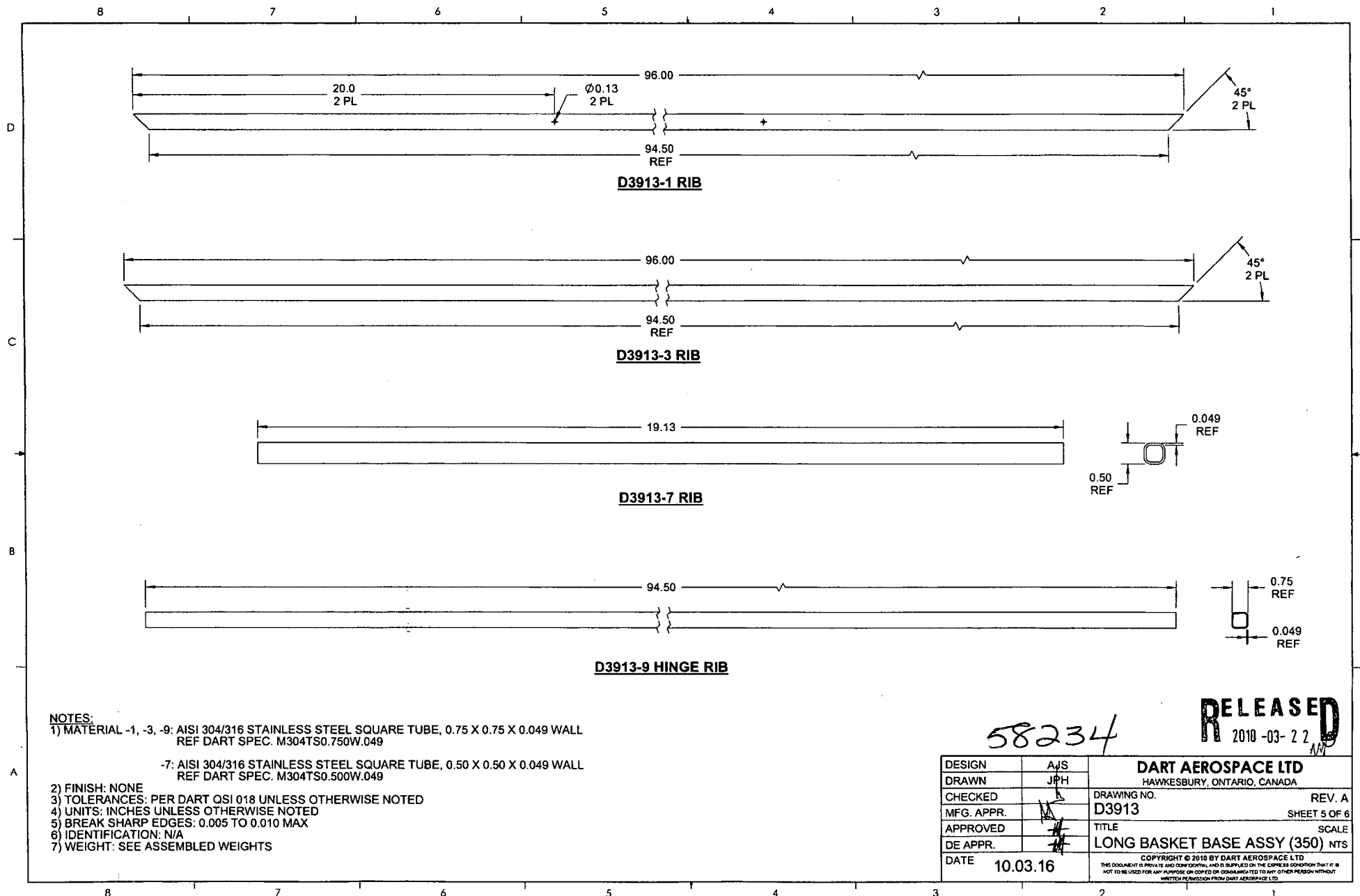
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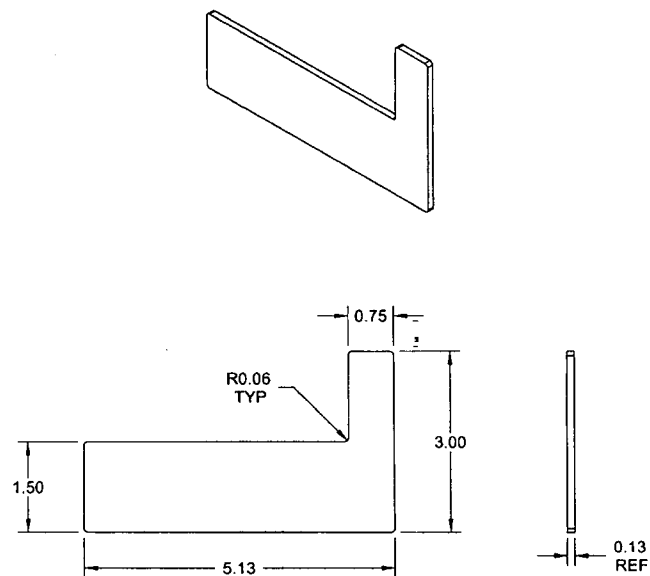
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JA	DRAWING NO.	REV. A
MFG. APPR.	JA	D3913	SHEET 4 OF 6
APPROVED	JA	TITLE	SCALE
DE APPR.	JA	LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED  
2010-03-22

58234





**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

**RELEASED**  
2010-03-22  
*WAP*

58234

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries